

**MACHINE TOOL AND PALLET CHANGER FOR MACHINE TOOL****ABSTRACT OF THE DISCLOSURE**

5           An APC is provided in a five-axis controlling vertical machining center. A spindle head is movable in three mutually transverse axes directions to a workpiece. A table disposed below swings to be positioned and is directed upwardly and indexed. A pallet setup base is provided outside a machining area. A pallet change arm has pallet  
10   grip portions for gripping and releasing the pallets. The arm makes a swivel motion and makes an ascending and descending motion. Thus, the pallet is transferred between the table and the pallet setup base and is received and discharged to the table and the pallet setup base.